

incorporated into the chromium-iron alloy. The metal sheet has a thickness which is generally less than 0.2 inch so that the metal shell members can be properly drawn over a die to form the metal shell members in the desired shapes.

5 The metal sheet is coated with a zinc-tin coating applied by a hot dipped process. The zinc-tin coating is a two-phase coating comprising a large weight percentage of zinc and a large weight percentage of tin. The tin content of the two-phase coating is at least 15 weight percent and  
10 the zinc content is at least 7 weight percent. Typically, the composition of the zinc-tin metallic coating is less than 35 weight percent tin and at least 65 weight percent zinc. The unique zinc-tin alloy combination provides an excellent corrosion-resistant coating that protects the  
15 surface of the metal material from oxidation and is also environmentally friendly thus immune from the prejudices associated with lead containing materials. The zinc-tin coating also provides excellent protection to petroleum receptacle containing petroleum products which include  
20 alcohols. Alcohol additives such as methanol or ethanol are commonly added to gasoline to reduce emission problems. These additives are highly corrosive to metals such as carbon steel and stainless steel. The zinc-tin coating provides superior corrosion protection against alcohol  
25 additives as compared to terne coated materials. Prior to coating the metal sheet, the exposed surface of the metal sheet is usually pretreated to remove foreign materials and oxides from the metal surface which could interfere with the bonding of the zinc-tin coating onto the metal sheet  
30 surface. If the metal sheet surface is stainless steel, a special pretreatment process disclosed in Assignee's Application Serial No. 08/000,101 filed on January 3, 1993 should be used. The pretreatment of the metal sheet surface allows for a strong bond to be formed between the zinc-tin  
35 coating and the surface of the metal sheet. Furthermore,

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